

Work Order ID 121266

June-20-14 10:46:45 AM

121266

Page 1

Item ID: D5090-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 6/20/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/20/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5090

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

7 EL 146-25

7 EL 146-25

6061 .040

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Page 2

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Setup Start

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Item Name: Bracket

Start Date: 6/20/14

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Required Date: 6/20/14

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2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

27
14/6/25 **DAS**
27
9-89

120

QC

Memo

0.00

Quality Control

(2)

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

DAS
30
9-89

2

14/6/25

140

QC5- Inspect part completeness to step on W/O

0.00

DAS
27
9-89
14/6/25

140

QC

Memo

0.00

Quality Control

3

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Run	Start	*NR1*
	Stop	*NR2*

**Insp.
Stamp**

0.00

1416/20

14/6/28

June-20-14 10:46:45 AM

Item ID: D5090-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 6/20/14 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 6/20/14 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number**Insp.
Stamp**

190

Identify as per dwg & Stock Location: 81444 0.00

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

24 147-7 DAS
26
9-89

MLJ 14-07-08

me
14-7-

Picklist Print

June-20-14 10:46:44 AM

Page 1

Work Order ID: 121266

121266

Parent Item: D5090-1

D5090-1

Parent Item Name: Bracket

Start Date: 6/20/14

Required Date: 6/20/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.06.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No				sf	234.5200		3			

M6061T6S 040

6061-T6 .040 Sheet

Q 14-6-25

Location

Loc Qty

Loc Code

MAT021

234.52

m126350

19.52

m126981

76.91

m128422

49.79

m129T65

88.3

2.5

8 7 6 5 4 3 2 1

D

D

C

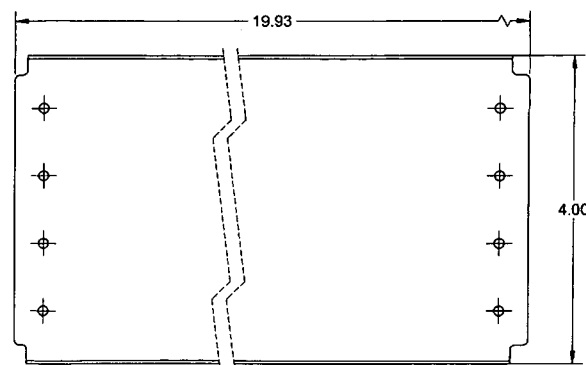
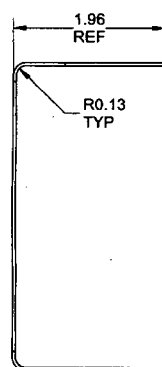
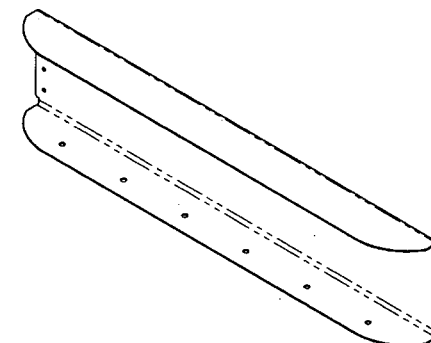
C

B

B

A

A



D5090-1 BRACKET

nr2lek

RELEASED
2014-06-16

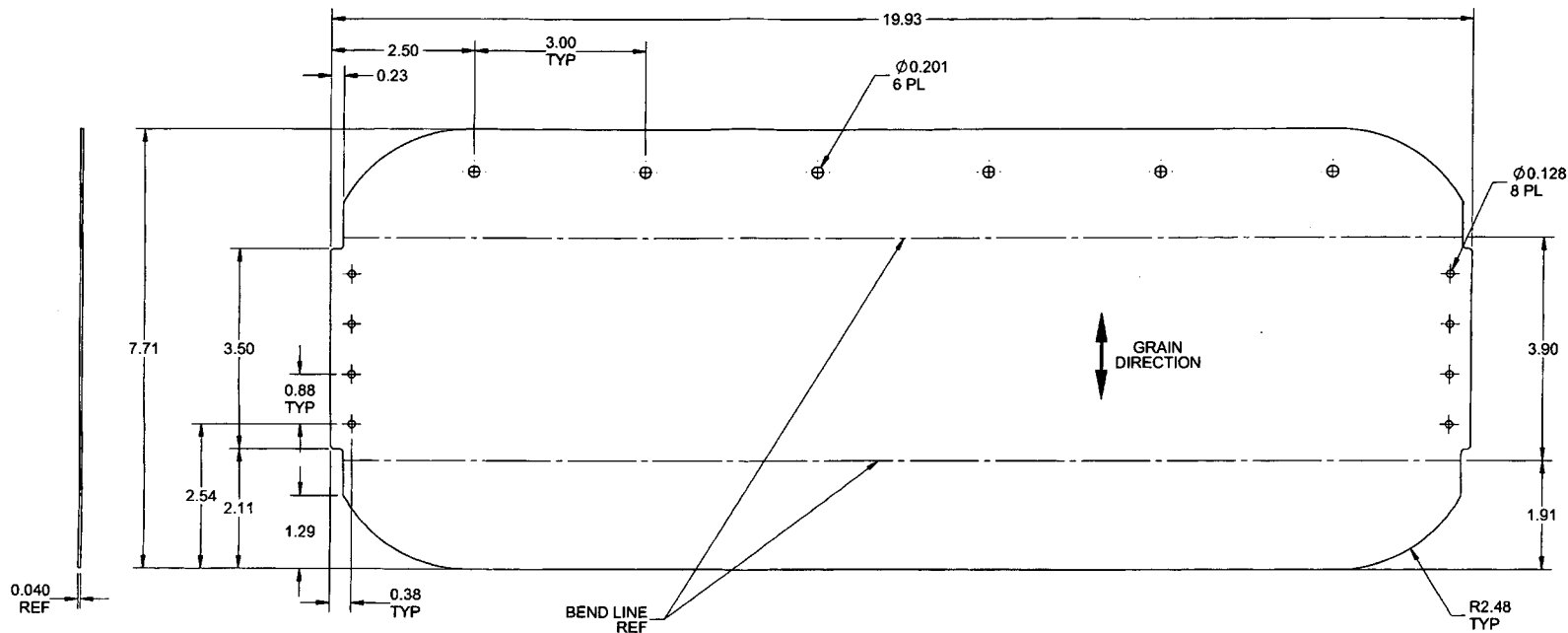
NOTES:

- 1) MATERIAL: MADE FROM D5090-1F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.58 lbs

APPROVED

DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5090	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
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8 7 6 5 4 3 2 1



D5090-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.58 lbs

RELEASED
11 2014-06-16
WPD

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CHECKED	RF	DRAWING NO.	REV. A
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